

Date: Thursday, 19/06/2008 9:53:42 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TOP PANEL ASS'Y
Job Number :	39951		
Estimate Number :	13034		
P.O. Number :		Part Number :	D36509
This Issue :	19/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3650 REV.B
First Issue :	1/1	Project Number :	N/A
Previous Run :	37060	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>JULIE 08.6.19</u>	Due Date :	30/06/2008
Comment :	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD verified by: EC Est Rev:C ecn1162 08-04-02 DD verified by: EC		

Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.0536 sf(s)/Unit Total: 0.1071 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 108415 HB 8-6-26

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3650

Dwg Rev: B
 Prog Rev: B

HB 8-6-26

(3)

2-Deburr if necessary

HB 8-6-26

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-6-26

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8 22/06/26 (R)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Form as per Dwg D3650

HB 08/07/26 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/06/2008 9:53:42 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANEL ASS'Y

Job Number: 39951

Part Number: D36509

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/07/16 (+3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock
Location: GA

SB 08/07/16 (3)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/17

Job Completion



MF 08-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

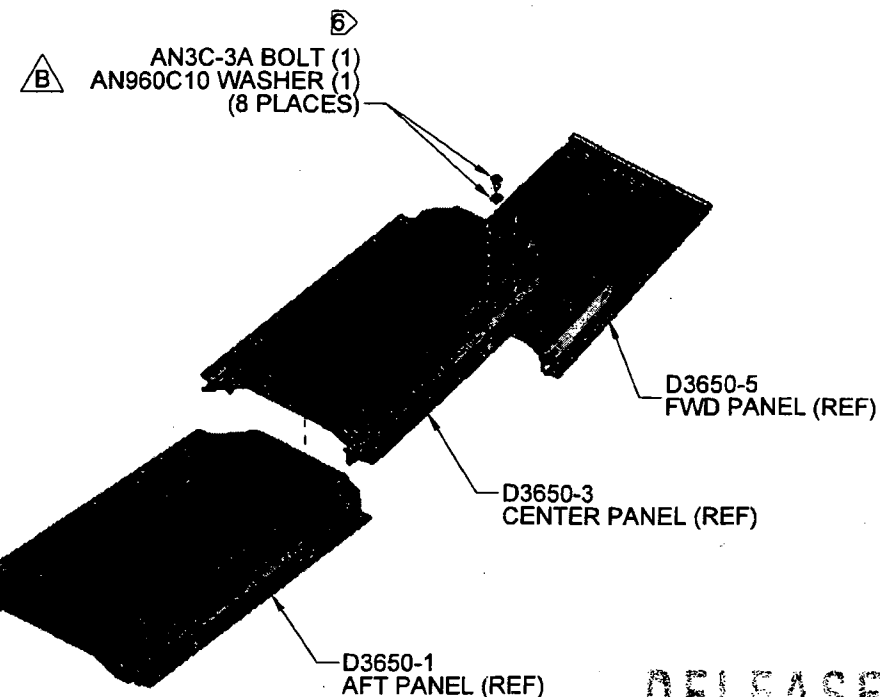
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

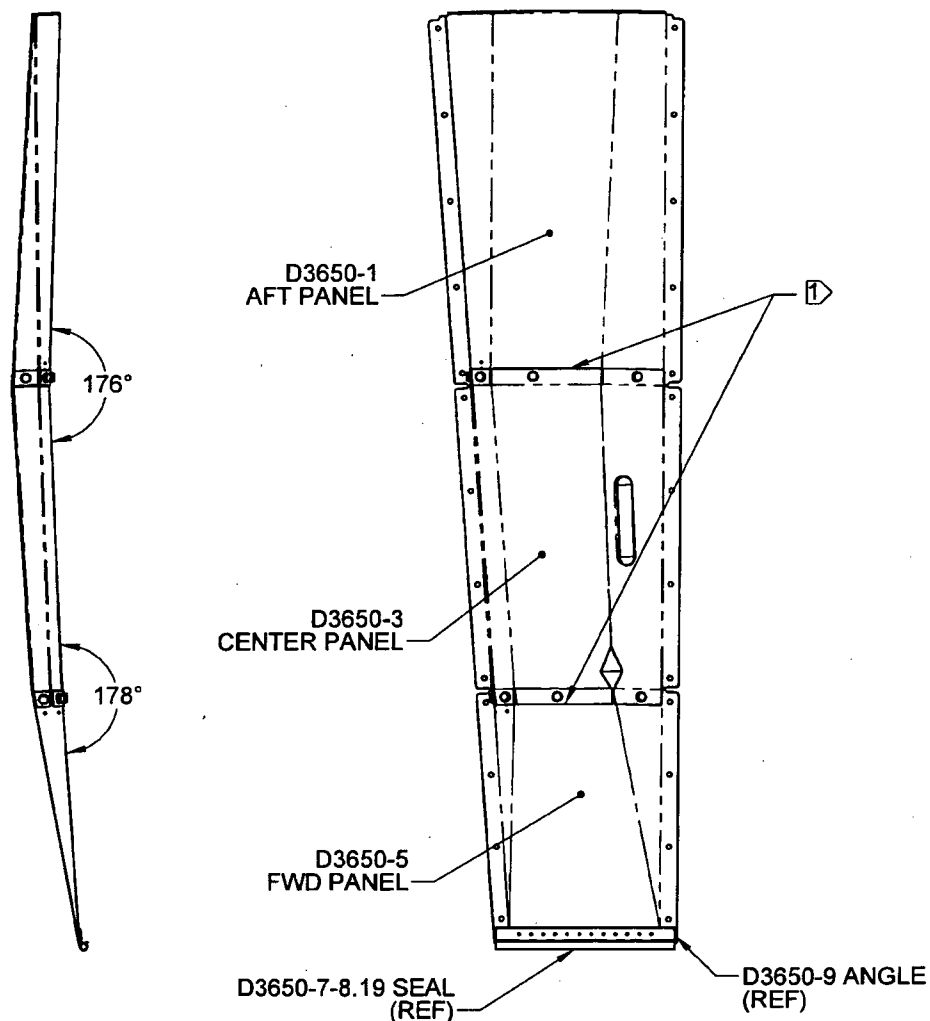
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



D3650-041 TUNNEL TOP PANEL ASSEMBLY

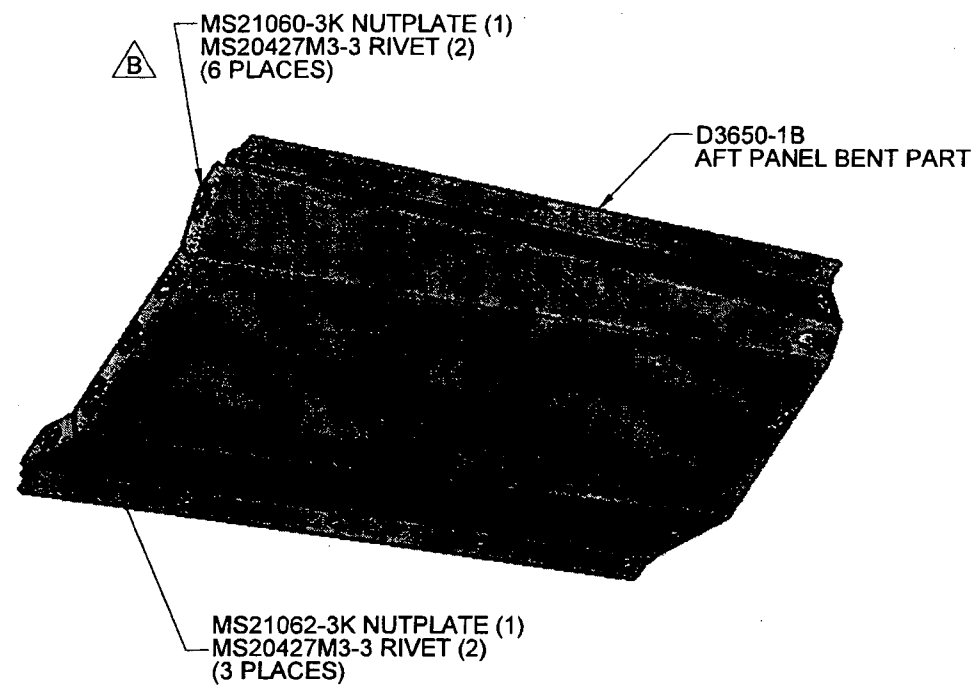
NOTES:

- 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: NONE
- 6) TORQUE FASTENERS 15 TO 25 in-lb
- 7) WEIGHT: 3.3 lbs

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11F-11F TO SHEET 9; ADDED DETAIL 1 SHEET 9: RELOCATED D3650-11F-11F FROM SHEET 6; UPDATED DIMS OF D3650-11F-11F	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 1 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TOP PANEL ASSEMBLY	1:8
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8 7 6 5 4 3 2 1

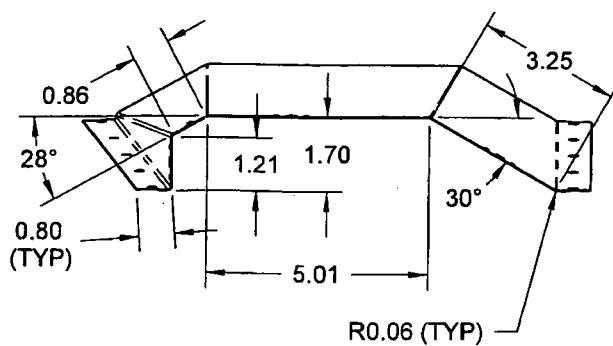
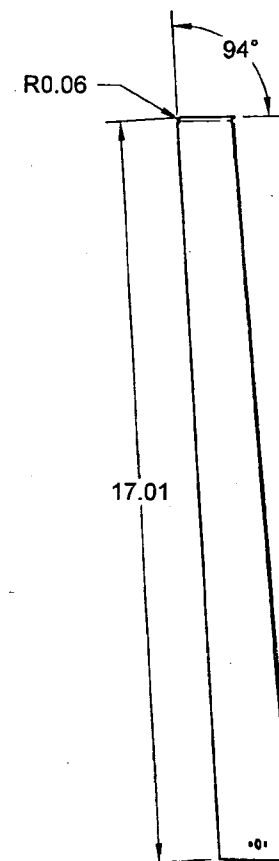
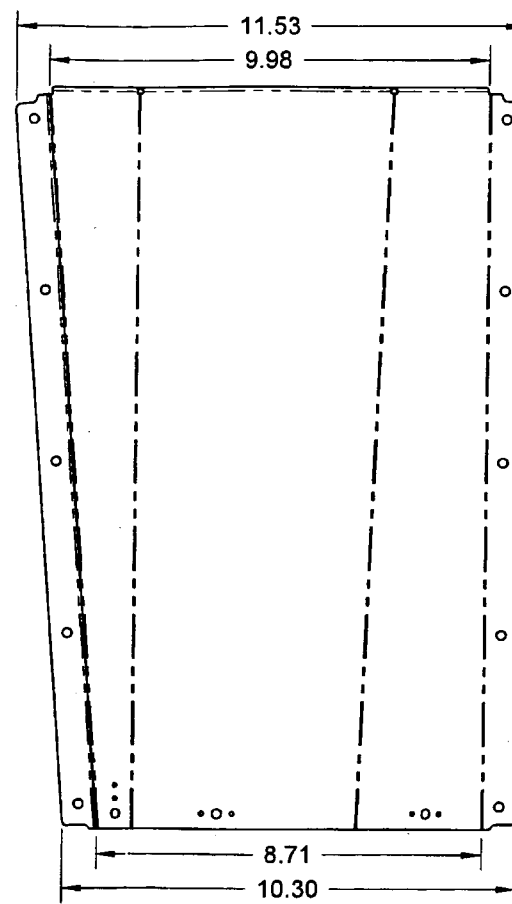
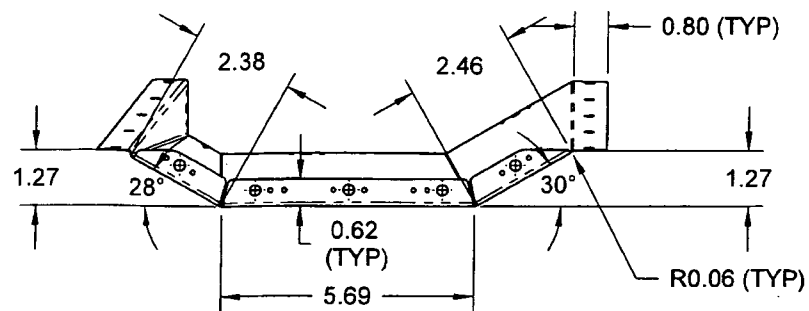


D3650-1 AFT PANEL

PART LIST

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE

- NOTES:**
- 1) FINISH: NONE
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: NONE
 - 6) WEIGHT: 1.3 lbs



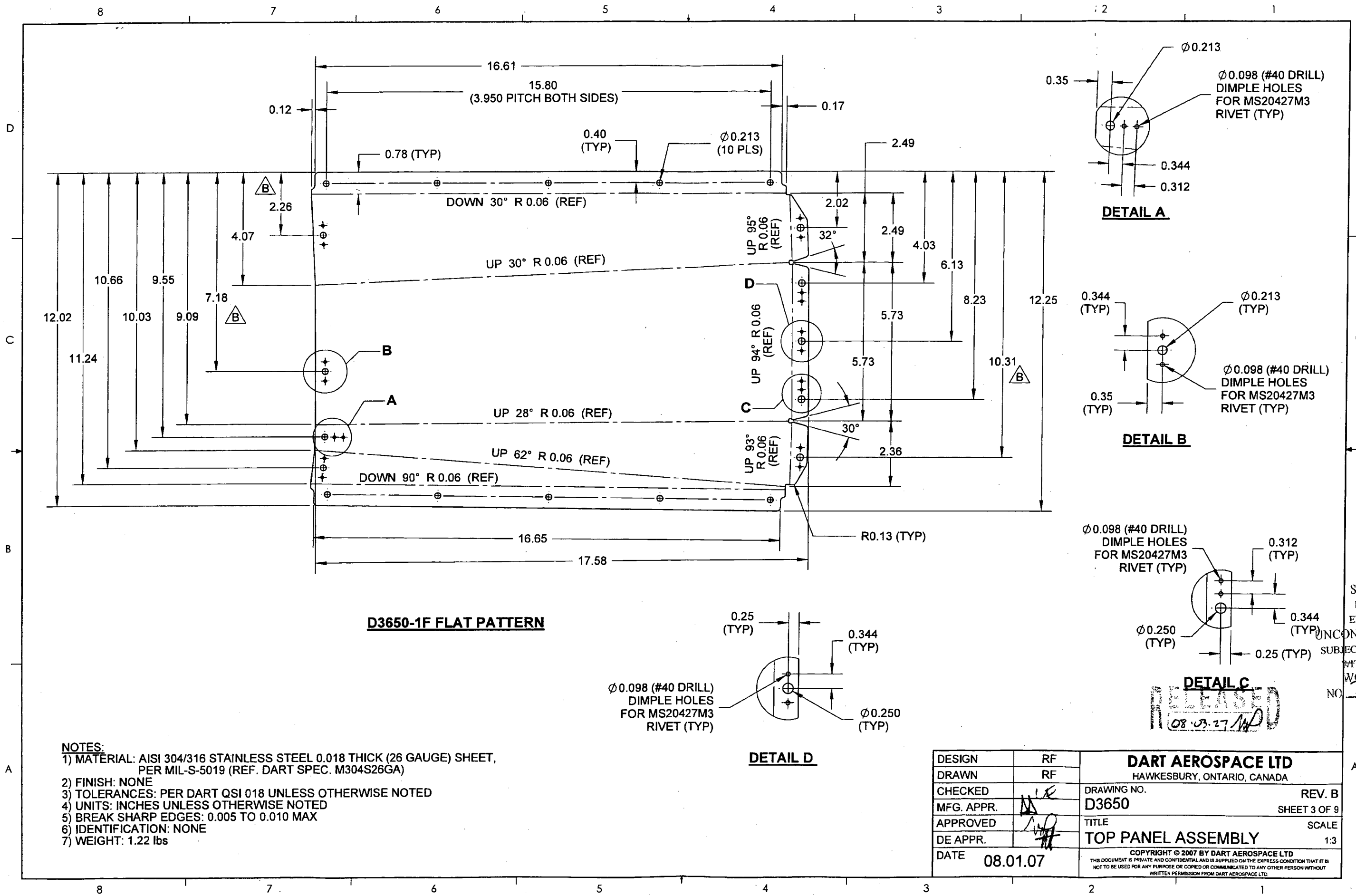
D3650-1B AFT PANEL BENT PART
(MAKE FROM D3650-1F FLAT PATTERN)

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
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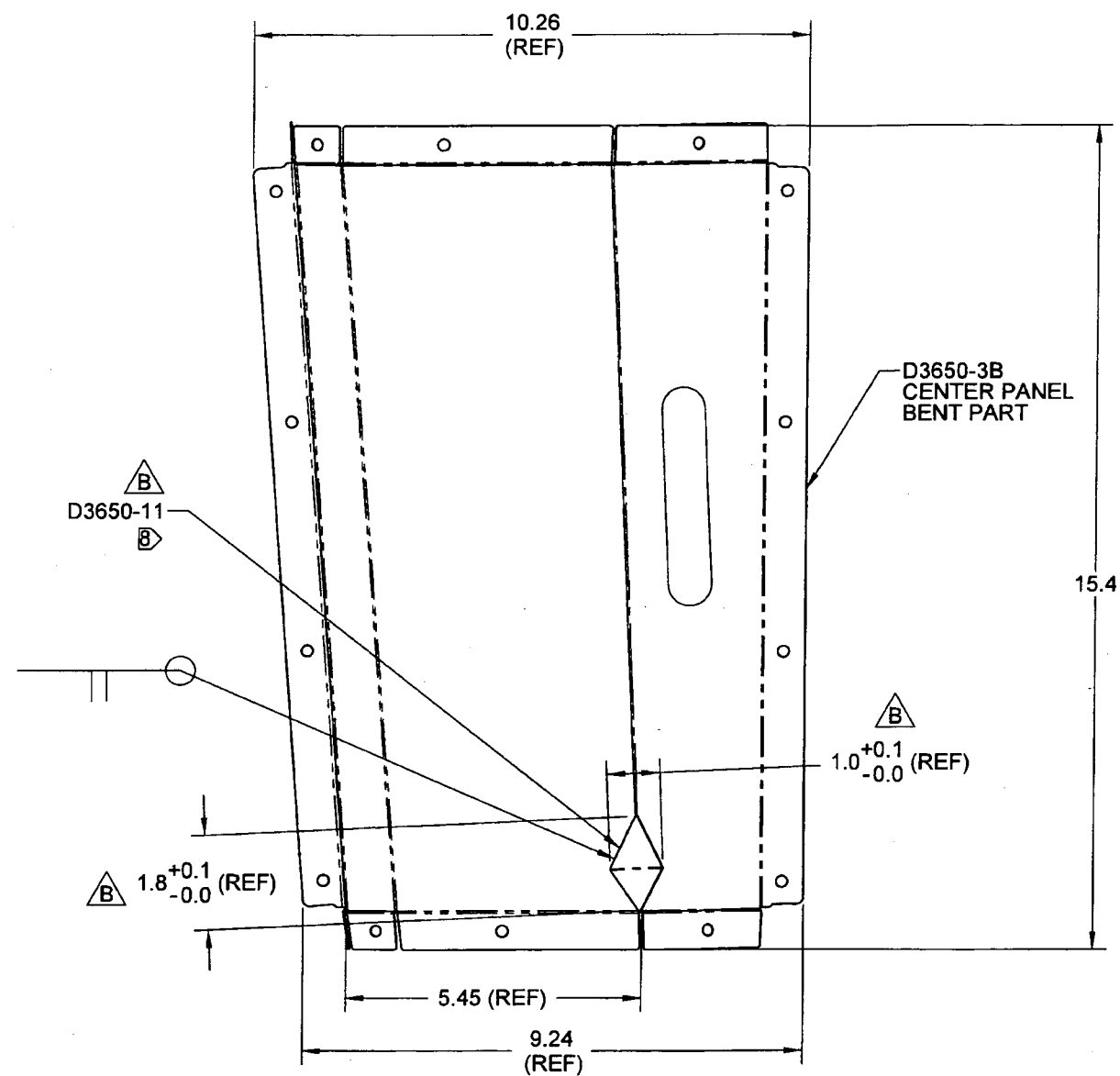
8 7 6 5 4 3 2 1



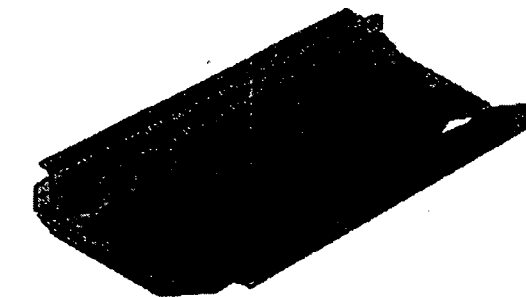
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.22 lbs

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:3
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D3650-3 CENTER PANEL



PART LIST

QTY	PART NUMBER	DESCRIPTION
-3		
X	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

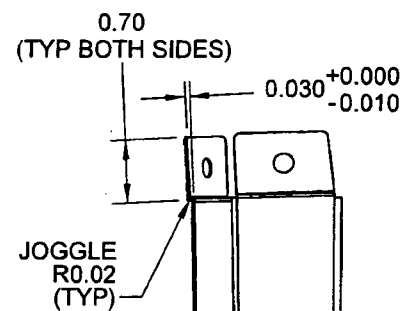
NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED

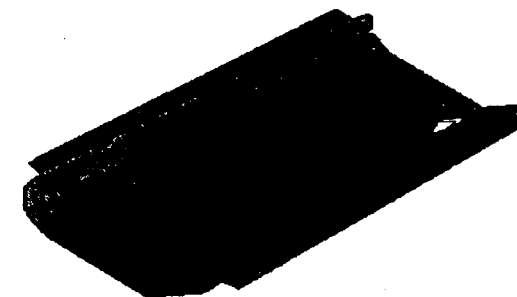
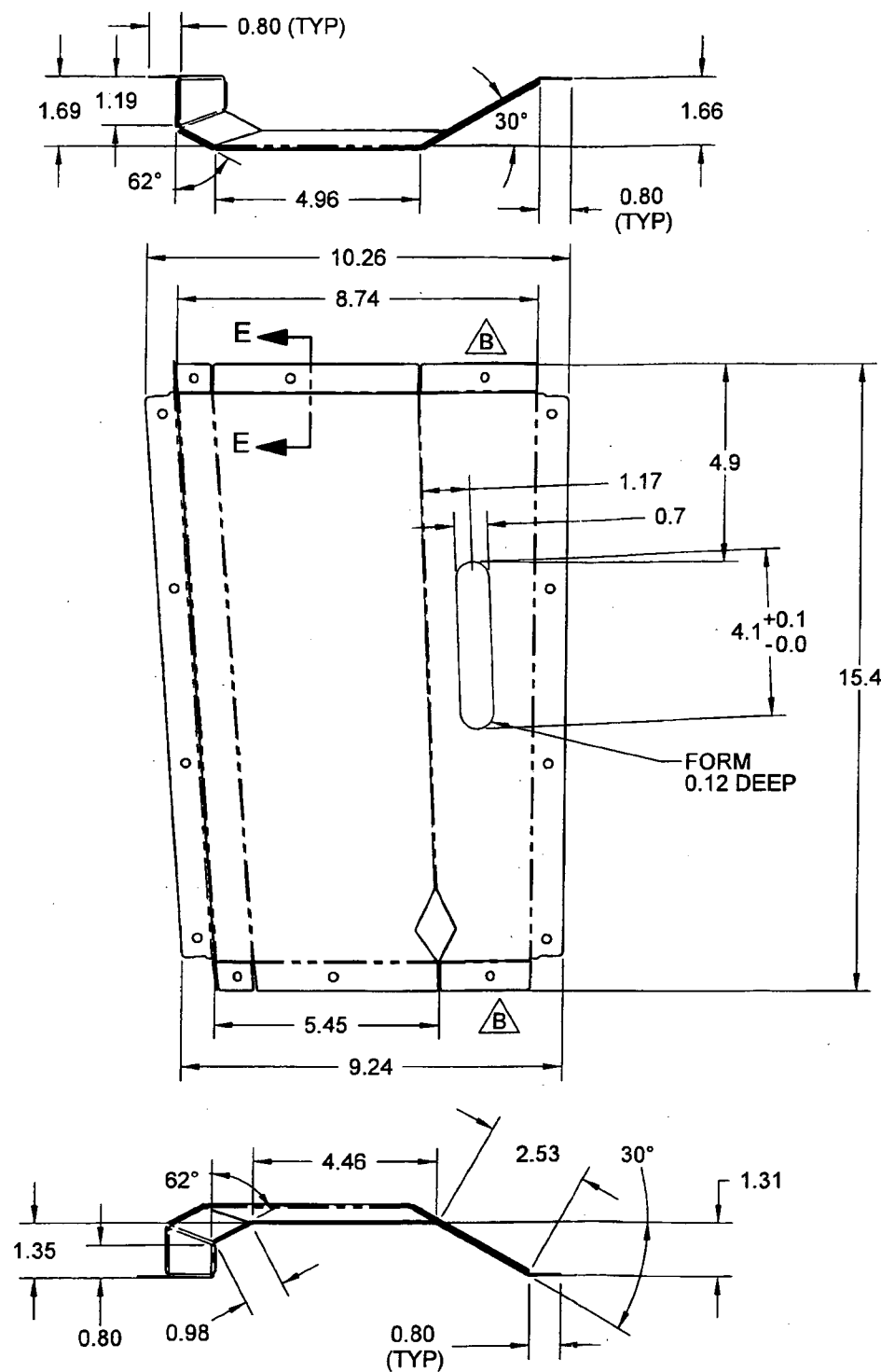
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CHECKED	LE	DRAWING NO. D3650	REV. B
MFG. APPR.			SHEET 4 OF 9
APPROVED		TITLE TOP PANEL ASSEMBLY	SCALE 1:3
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.01.07		



SECTION E-E



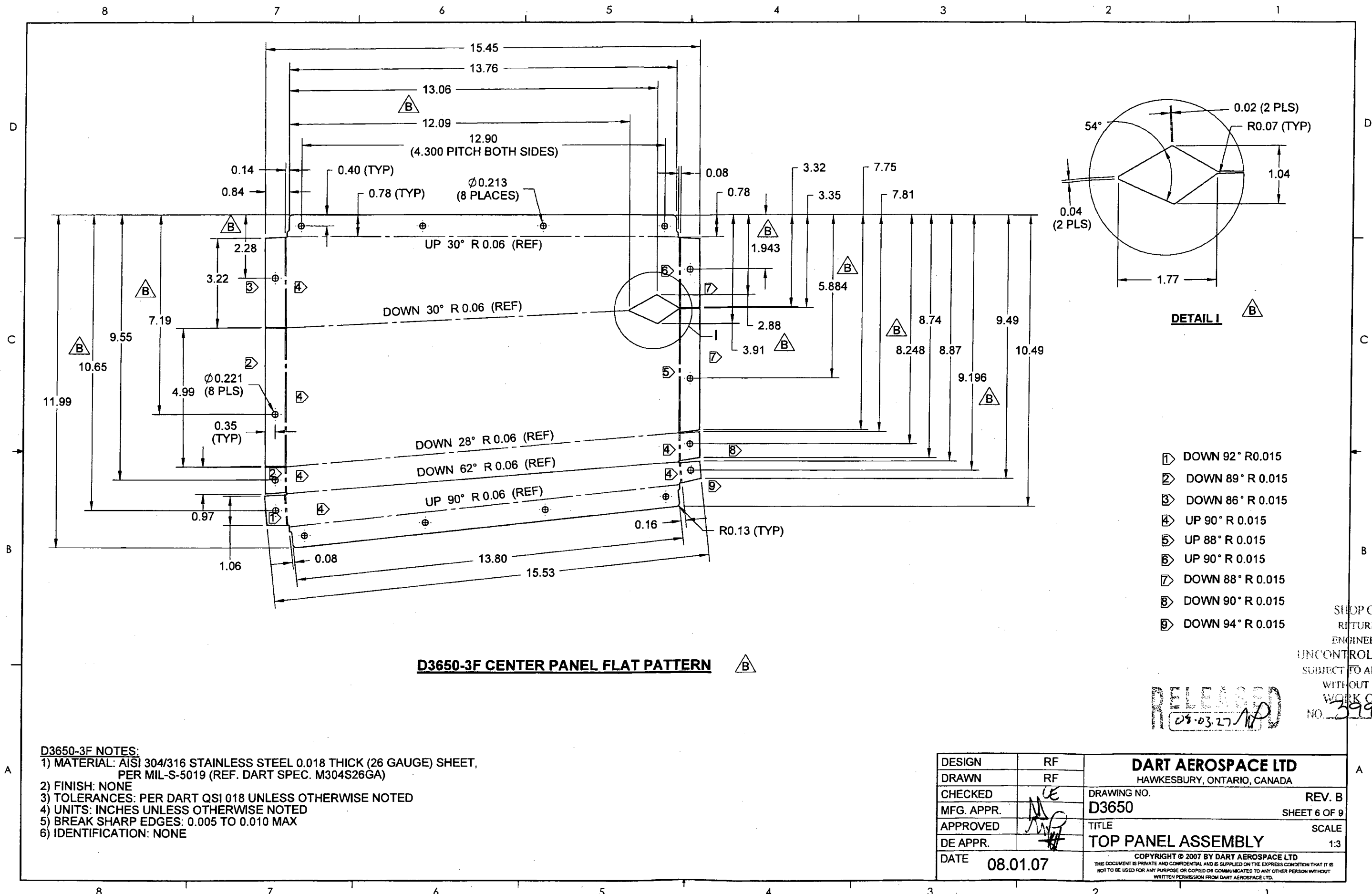
- NOTES:**
- 1) FINISH: NONE
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE

D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

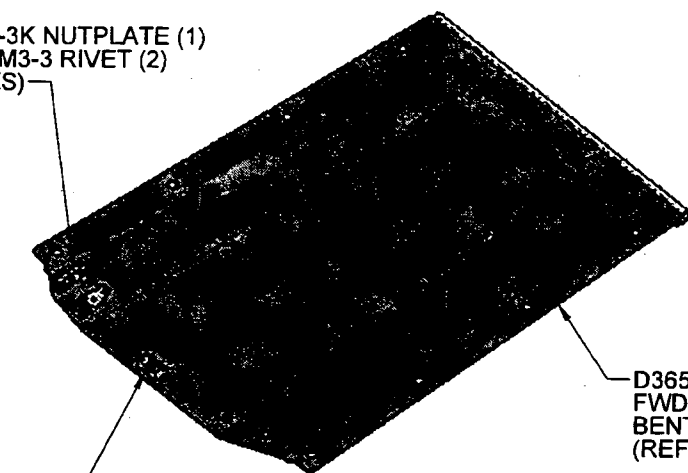
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV.
MFG. APPR.		D3650	SHEET 5 OF
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:
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08-03-27/10P



MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)



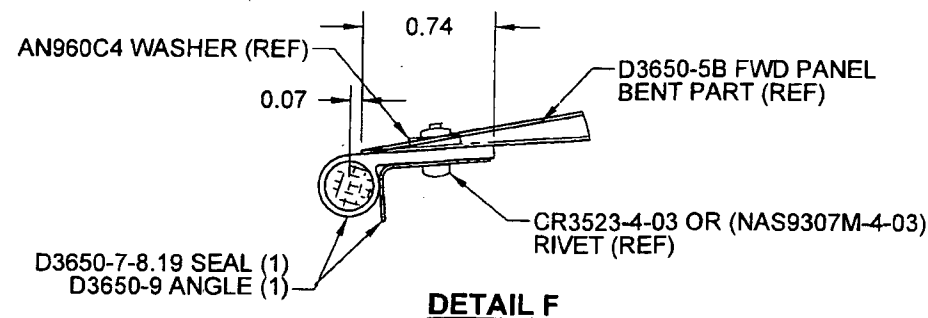
MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

PART LIST

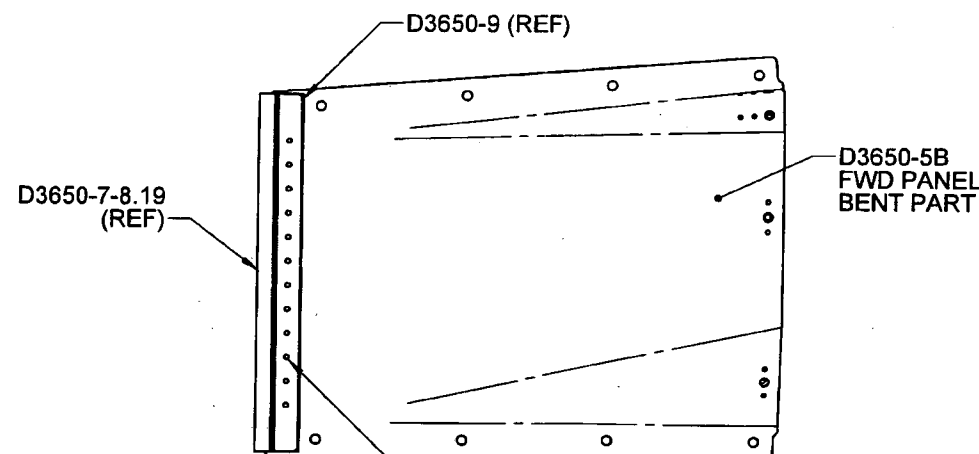
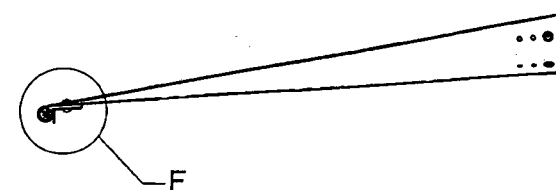
QTY	PART NUMBER	DESCRIPTION
5	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

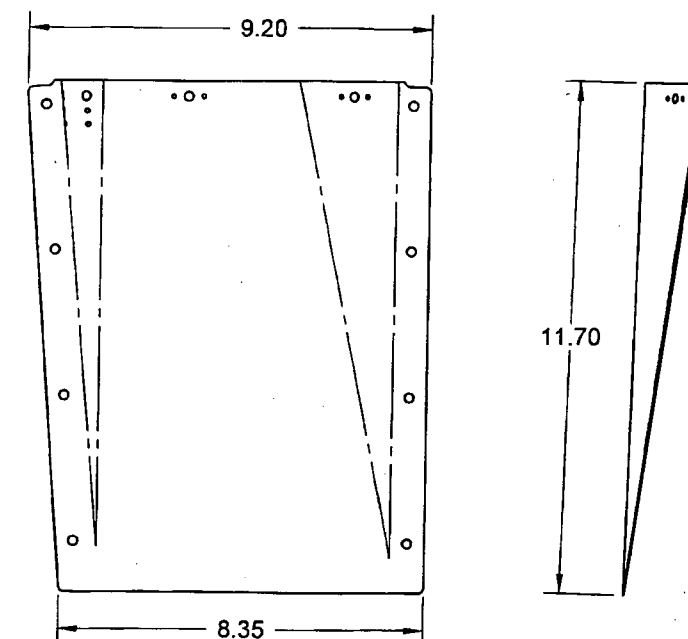
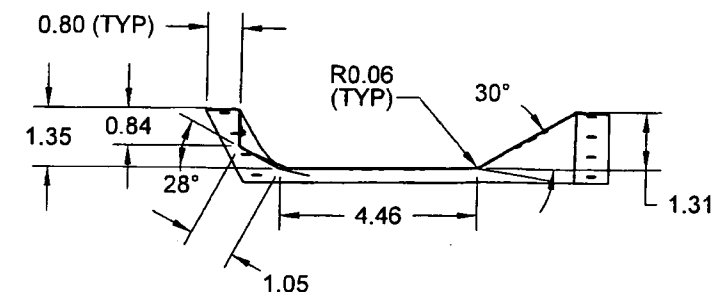


DETAIL F



D3650-5 FWD PANEL

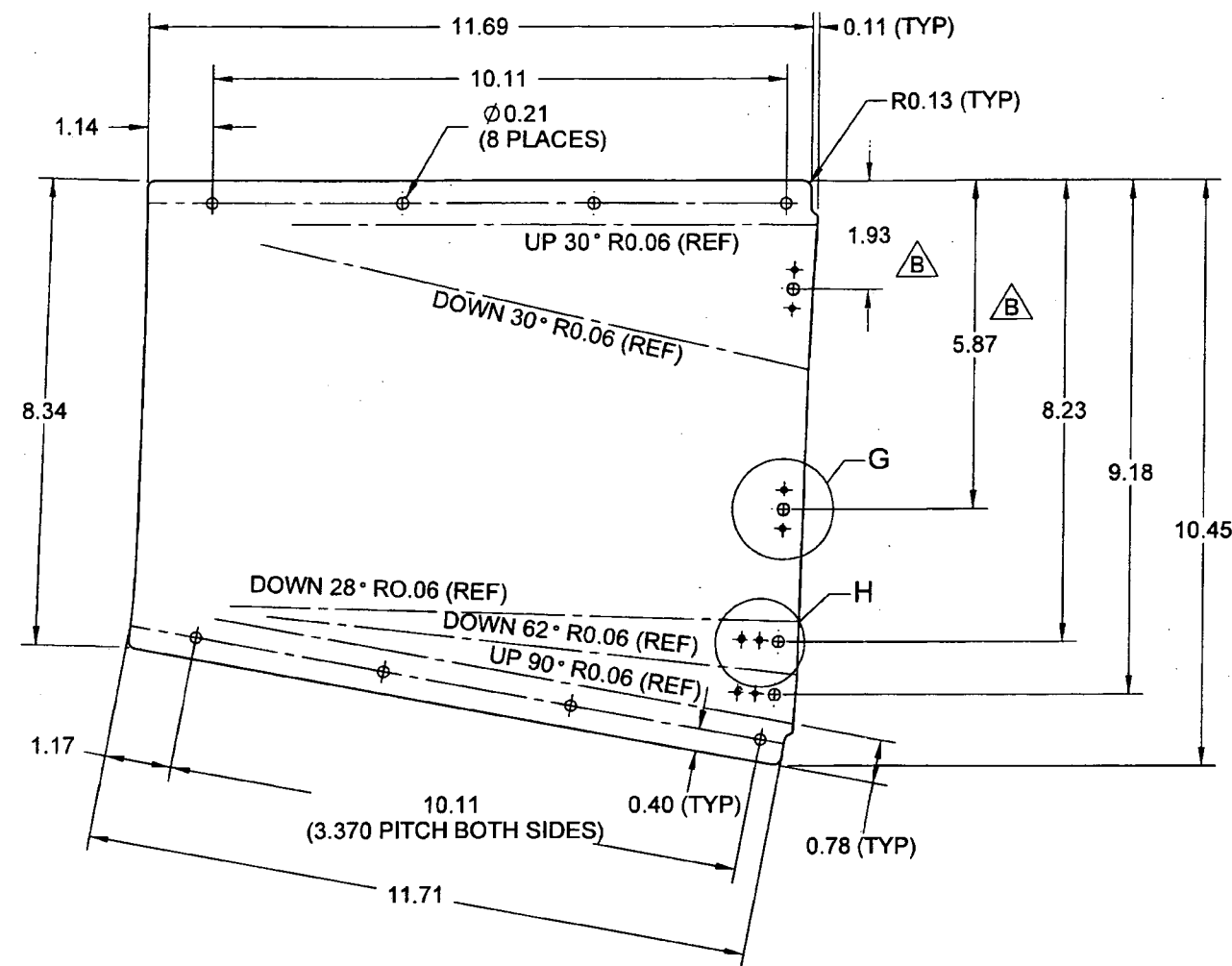
CENTRE D3650-7/-9 ON D3650-5B & TRANSFER $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3650-9 TO D3650-7 & D3650-5B AS SHOWN
INSTALL
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)



D3650-5B FWD PANEL BENT PART (MAKE FROM D3650-5F FLAT PATTERN)

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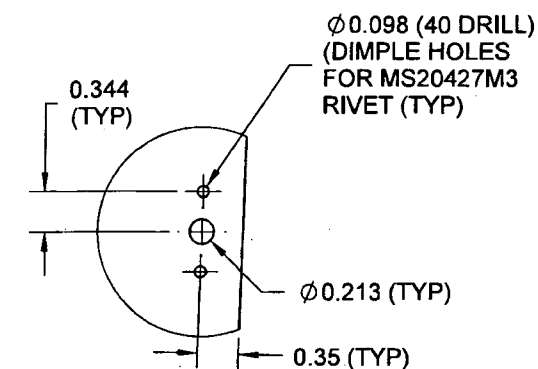
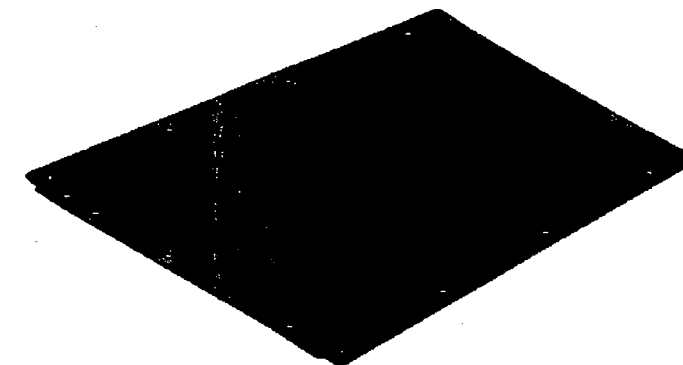
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VE	DRAWING NO.	REV. B
MFG. APPR.	MP	D3650	SHEET 7 OF 9
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	TOP PANEL ASSEMBLY	1:4
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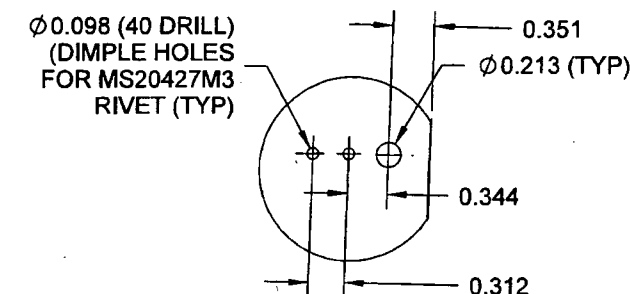
D3650-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb



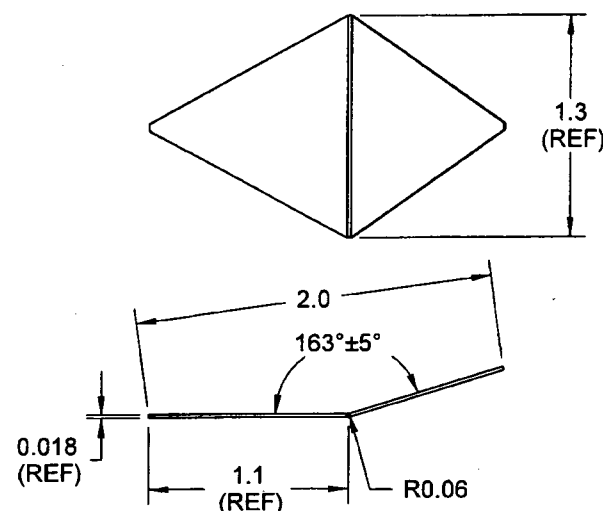
DETAIL G
(2 PLS)



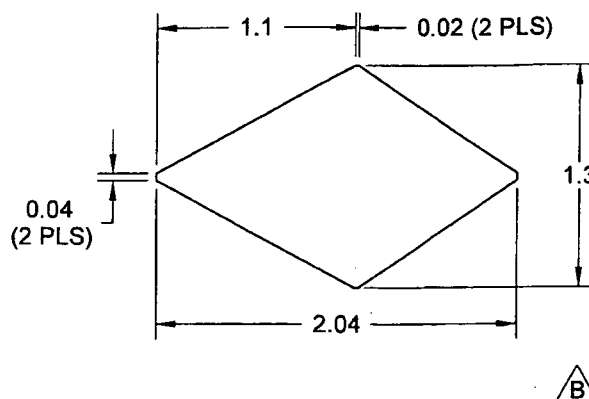
DETAIL H
(2 PLS)

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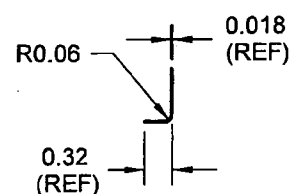
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	KE	D3650	SHEET 8 OF 9
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	TOP PANEL ASSEMBLY	1:3
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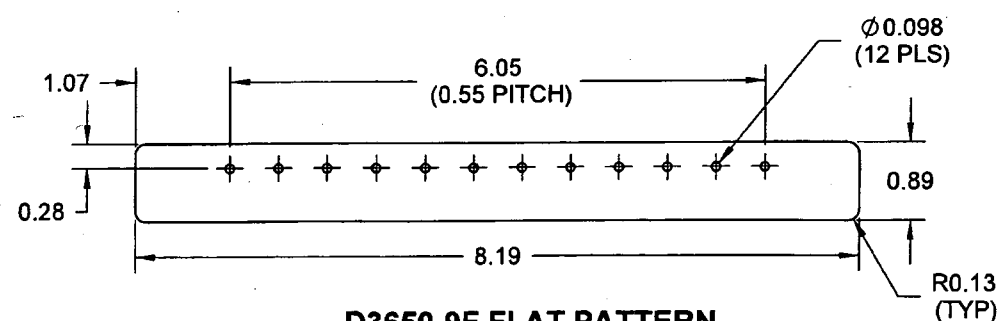
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



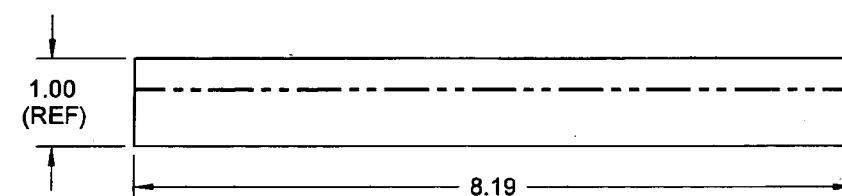
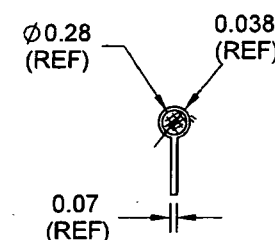
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-9F FLAT PATTERN



D3650-7-8.19 SEAL

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3650	SHEET 9 OF 9
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	TOP PANEL ASSEMBLY	1:2
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